Work Order ID 100432

QC

Quality Control

100432

Page 1

April-22-13 1:40:15 PM Accept Item ID: D4021-7 *N900040100* Setup Start **Revision ID:** Stop Item Name: Hoop **Start Qty: 30.00 Start Date:** 4/22/13 **Cust Item ID:** Req'd Qty: 30.00 Required Date: 5/03/13 **Customer:** Reference: . Start Run Process Plan: MLJ Date: 13-04-23 Tooling: Approvals: Date: Stop Date: SPC (Y/N): Date: Tool ID Reject Reject Set Up/ Tool # Plan Sequence ID/ Operation Accept Insp. Description Qty Qty Number Stamp Work Center ID Code **Run Hours Revision Nbr Draw Nbr** D4021 В 0.00 100 Jm 13-4-24 *100* 0.00 Waterjet Memo Cut as per dwg D4021 FLOW CNC Waterjet Prog Rev:_ Dwg Rev: Drill 0.194 Holes on Drill Press Deburr as required 110 QC2- Inspect parts off machine FAI/FAIB 0.00 *110* Jm 13-4-24

0.00

Memo

	•		1								DQA:	Date:	
NCR:	es.	/ No				WORK ORDER NON-C	O	NFORM	MANCE / UP	DATE	QA Closed:		
												Date:	
Work Orde	er:		1			DISPOSITION	AGAINST DE			PARTMENT	/PROCESS		
Part No.						Rework Scrap		r	Skid-tube Crosstube Small Fab Thermoforming Finishing		Water Jet Prod. Eng. Coor. Rec/Store/Packaging		Engineering Quality Other
NCR I	No.				<u>-</u>	Use-as-is Work Order Update]	mem	Large Fab	Finishing Composite	, Recysto	Supplier	
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Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector
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		Bending				Bend		Grain			Ovalized	<u>_</u>	Pressure/Forced
		Centre No	ot Conce	ntric to	o/s	BOM/Route	L	Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	ion Incomplete	<u></u>	Part Incorre	ct	Weld
		Crushed/	Crimped			Burrs		Instruct	ions Incomplete,	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
٠.		Cuffs		9	[·	Contamination		Mainte	enance		Part Moved		
		Heat Trea	at			Countersink		Mislabe	eled		Positioned \	Vrong	_
	Г	Inspectio	n Strip in	Tube		Cut Too Short		Misread	d		Power Loss/	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

140

QC5- Inspect part completeness to step on W/O

36

140

Memo

2- deburr

Quality Control

											DQA:	Date:	
NCR: Y	es / No	٠			WORK ORDER NON-C	COL	NFORI	MANCE / UP	DATE	QA Closed: Date: NST DEPARTMENT/PROCESS Tube Water Jet Engineering Quality Fab Prod. Eng. Coor. Quality hing Rec/Store/Packaging Other			
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Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish

Page 3

April-22-13 1:40:15 PM

Required Date: 5/03/13

Item ID:

D4021-7

Accept

N900040100

Setup Start

Revision ID: Item Name:

Start Date:

Hoop

4/22/13

Start Qty: 30.00

Req'd Qty: 30.00

30

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan: QC:

Date: Date:

Tooling:

Date:

Date:

Run

Stop

Sequence ID/

Operation Work Center ID

Description Identify as per dwg & Stock Location: WA 4

Set Up/ **Run Hours** 0.00

SPC (Y/N):

Tool # Plan

Code

Accept Qty

Reject Reject Qty

Insp. Number Stamp

150

150

Packaging

Memo

0.00

Packaging

160

160 OC

Quality Control

Memo

QC21- Final Inspection - Work Order Release

0.00

0.00

										D	QA:	D	ate:		
NCR: Y	es / No				WORK ORDER NON-C	CON	NFORM	MANCE / UP	DATE			- · · · · · · · · · · · · · · · · · · ·			
		ı			_	,				QA Clos	sed:	D	ate:		
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					Use-as-is	1	Therm	noforming	Finishing	Rec/	Stor	e/Packaginį	\Box	Other	
NCR N	lo				Work Order Update]		Large Fab	Composite			Supplie	r		
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	Inspectio		Tube	<u> </u>	Cut Too Short		Misread	l	Ĺ	Power L	oss/S	Surge	Ш	Other	-
	Ripples in		_	-	Drill Holes	-	Offset								-
	Torque V			n	Drawing	<u> </u>	4	Calibration							-
	Turning 9	Sequence	!	- 1	Finish	[Out of S	equence							

Outside Dimensions

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

April-22-13 1:40:14 PM

Page 1

Work Order ID:

100432

Parent Item:

D4021-7

Parent Item Name:

Hoop

Start Date: 4/22/13

Required Date: 5/03/13

Start Qty: 30.00

Required Qty: 30.00

Comments:

IPP RevA: new issue DD 09.11.25 verified by:EC

IPP Rev:B as per dwg REV.A DD

	10.02.22 verified t	by:EC IPP Re	v:C as per dwg revB	DD 10.04.20 ver	ified by:EC						
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Date Issued Issued	Status
M304B0.625X3.000 304 BAR .625 X 3.00		Purchased	No		100	f .	7.0000	0.4166	13.15578	o lo ft.	In13-4-23

Location	Loc Oty	Loc Code	
MAT049	7		
123097	4		4
123721	3		3

											DQA:	Date	·
NCR: Y	es /	No				WORK ORDER NON-C	O	NFORN	MANCE / UP	DATE	QA Closed:	Date	:
144IOI	2.					DISPOSITION				AGAINST DE	<u> </u>		· · · · · · · · · · · · · · · · · · ·
Work Order: Part No.						Scrap Ma Use-as-is Thermo		Skid-tube Crosstube Small Fab Finishing		Water Jet Prod. Eng. Coor. Rec/Store/Packaging		Engineering Quality Other	
NCR N	No	1				Work Order Update]		Large Fab	Composite	J	Supplier	
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Cause Doc/Data		Jate	Steh	Qty		or Non-comormance	Ci	ilei ciig	Desci	праоп	Date	Vermeution	Qe inspector
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	∐Cr	ushed/	Crimped			Burrs	\vdash	-1	ions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Щcı	ffs				Contamination	L	Mainte			Part Moved		
,	Шне	at Trea	it .			Countersink		Mislabe	led		Positioned \	-	
	In:	pection	n Strip in	Tube		Cut Too Short		Misread	1		Power Loss,	'Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

DART AEROSPACE LTD	Work Order:	100432	
Description: Hoop	Part Number:	D4021-7	
Inspection Dwg: D4021 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

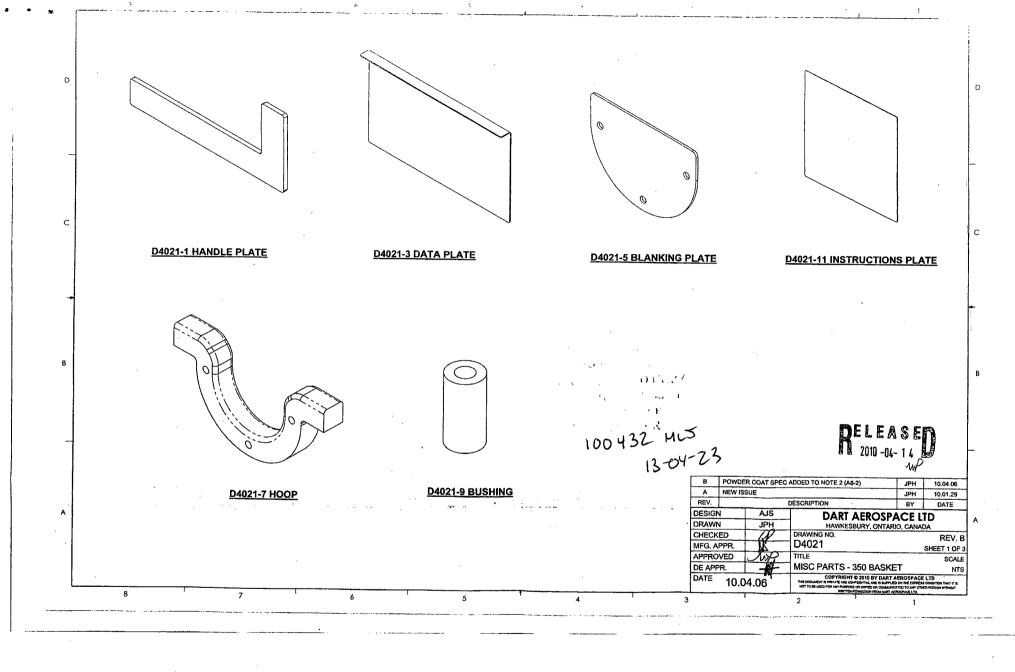
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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1.38	+/-0.030	1.366°			ν	
2.25	+/-0.030	2.245"	-		V	
5.00	+/-0.030	4.980	~		V	
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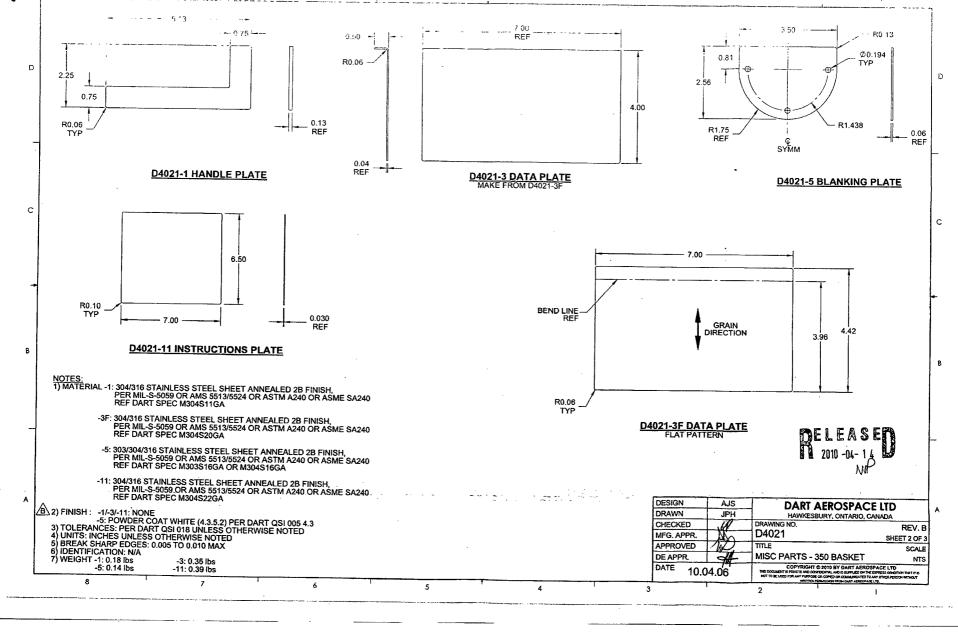
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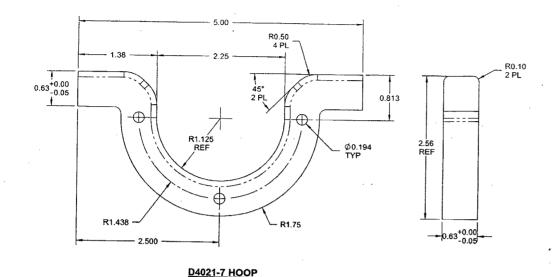
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Measured by: Jm	Audited by:	SMD	Preliminary Approval:	N/A
Date: 13-4-23	Date:	12424	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	10.04.01	New Issue	KJ,	7.1
В	10.08.18	Dimensions revised per Dwg Rev B	KJ KJ	
				144







Ø0.191 --0.75 **D4021-9 BUSHING**

MP

DESIGN AJS DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN JPH CHECKED DRAWING NO. REV. B D4021 MFG. APPR SHEET 3 OF 3 APPROVED TITLE SCALE DE APPR. MISC PARTS - 350 BASKET COPYRIGHT © 2010 BY DART AEROSPACE LTD
THE DOCUMENT OF PRINT ON CONCERNMENT, WICE SUPPLIED ON THE PRINT OF TH NTS DATE 10.04.06

NOTES: 1) MATERIAL-7: 304/316 STAINLESS STEEL BAR, PER ASTM A276 REF DART SPEC M304B

-9: 304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276
REF DART SPEC M304R
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NA

6) IDENTIFICATION: N/A 7) WEIGHT -7: 0.80 lbs -9: 0.02 lbs